

Work Order ID 159006

Tuesday, April 04, 2017 2:38:25 PM

159006

Page 1

Item ID: D4405-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Eye And Fork Swivel

Start Date: 4/6/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/17/2017 Req'd Qty: 2.00

2

Customer:

Reference: SCHEDULED

DAS

Approvals:

Process Plan:

21

9-89

Date: APR 05 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4405	A

100

0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: 35878
Manufacture as per Dwg D4405
Possible Supplier: McMaster Carr
Material release note required

4 APR 06 2017 DAS 13 9-89

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.04

Packaging

4x SP17-4-11

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

4 APR 11 2017 DAS 38 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 159006

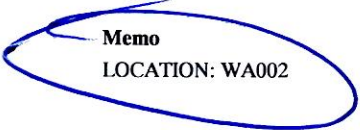
Tuesday, April 04, 2017 2:38:25 PM

159006

Page 2

Item ID: D4405-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Eye And Fork Swivel
Start Date: 4/6/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 4/17/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging		0.02							
Packaging	 Memo LOCATION: WA002								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.20							
Quality Control									

DAS
21
9-89
2017/04/284
DAS
6
9-89

APR 13 2017

17/4/19 

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Misabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Picklist Print

Tuesday, April 04, 2017 2:38:25 PM

Page 1

Work Order ID: 159006

159006

Parent Item: D4405-1

D4405-1

Parent Item Name: Eye And Fork Swivel

Start Date: 4/6/2017

Required Date: 4/17/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 11.05.24 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

30365T35		Purchased	No			100	Each	0.0000	1				
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30365T35

Swivel Eye & Fork

24
4x 8017-4-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

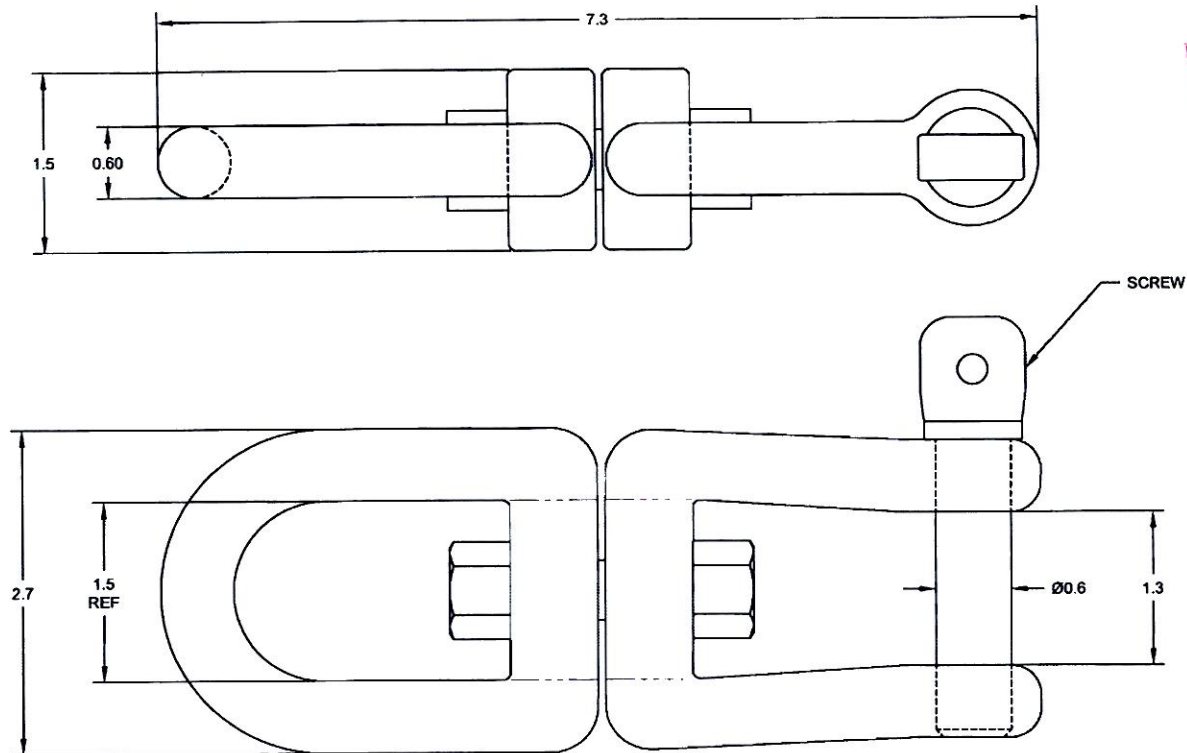
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Misidentified ☐	Past Due ☐																																																																

SPECIFICATION CONTROL DRAWING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 159006 MJS
17-04-05



D4405-1 EYE AND FORK SWIVEL

NOTES:

- 1) MATERIAL: STAINLESS STEEL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.0 lbs APPROX
- 8) PREFERRED SUPPLIER McMASTER CARR PART NUMBER 30365T35
- 9) THIS PART IS NOT AIRWORTHY

RELEASED
2011-05-18
[Signature]

A		NEW ISSUE		AJS	11.05.18
REV.		DESCRIPTION		BY	DATE
DESIGN		AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		AJS			
CHECKED				DRAWING NO.	REV. A
MFG. APPR.				D4405	SHEET 1 OF 1
APPROVED				TITLE	SCALE
DE APPR.		N/A		EYE AND FORK SWIVEL - S.C.D	NTS
DATE		11.05.18		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO35878

Purchase Order Date 4/6/2017

PO Print Date 4/6/2017

Page Number 2 of 5

Order From :
MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 330 995 5500
Ship To Contact
Ship To Phone
Ship Via: Purolator ground ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency USD
FOB FCA - (Free Carrier)

3	95606A170	Washer	4/10/2017	100.00	\$0.09	\$8.60
			Yes	Each		
			4/10/2017			

AS PER DWG D3631 REV. A
B159137

Line Total: \$8.60

4	30365T35	Swivel Eye & Fork	4/10/2017	4.00	\$69.79	\$279.16
			Yes	Each		
			4/10/2017			

AS PER DWG D4405 REV. A
B159006

Line Total: \$279.16

5	59915K274	Rod End Bearing	4/10/2017	10.00	\$19.05	\$190.50
			Yes	Each		
			4/10/2017			

AS PER DWG D4777 REV. A
B159131

Line Total: \$190.50

Note:

4/6/2017



200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO35878

Order Placed By
Chantal Lavoie

McMaster-Carr Number
1560781-02

Page 1 of 1

04/06/2017

Line	Product	Ordered	Shipped
2	6605K56 Hook and Loop Cable Ties 24" Overall Length, Meets UL 94V2, Packs of 5	3 Packs	3
3	95606A170 Nylon Plastic Washer for 7/16" Screw Size, 0.5" ID, 0.688" OD, Off-White, Packs of 100	1 Pack	1
4	30365T35 Eye-to-Clevis Swivel - Not for Lifting 316 Stainless Steel, 5-3/4" Long	4 Each	4 9-89
5	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End 3/8"-24 RH Male Shank, 3/8" Ball ID, 1-1/4" Long Thread	10 Each	10
6	98470A133 18-8 Stainless Steel Shoulder-Style Quick-Release Pin Ring Grip, 1/4" Diameter, 1.3" Usable Length	10 Each	10
7	29045A777 Long-Life TiN-Coated High-Speed Steel Jobbers' Drill Bit Wire Gauge 52, 1-7/8" Overall Length, 0.8" Drill Depth, 135Deg Point	3 Each	3
8	91251A353 Black-Oxide Alloy Steel Socket Head Screw 10-32 Thread Size, 2" Long, Partially Threaded, Packs of 25	6 Packs	6
9	6713A22 220 Grit Stone Set for 11/16" - 2-1/2" ID Flexible Precision-Finish Cylinder Hone	1 Each	1
10	3099K42 Digital Food and Beverage Pocket Thermometer	1 Each	1
11	7509A82 Gasketing Adhesive 3M 1300L, 32 oz. Can	3 Each	3
12	1372N35 Multipurpose Neoprene Rubber Strip with Certificate, 2" x 36", 1/8" Thick, 50A Durometer	15 Each	4

Shipped separately from our Chicago warehouse on 04/06

1	86715K27 High-Strength Oil-Resistant Buna-N Rubber Sheet Adhesive Back, 1/16" Thick, 12" X12", 60A Durometer	4 Each	4
12	1372N35 Multipurpose Neoprene Rubber Strip with Certificate, 2" x 36", 1/8" Thick, 50A Durometer	15 Each	11

Notes about your shipment

The U.S. Department of Transportation regulates the shipping of lines 10 and 11. By purchasing from McMaster-Carr Supply Company, you agree not to transport or permit others to transport purchased items except in accordance with U.S. law and any other applicable laws.